

**Work Order ID 66027**

Wednesday, February 02, 2011 9:11:44 AM



Page 1

Item ID: D3908-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Aft 4

Start Date: 2/3/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 2/16/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: YMF Date: 11-02-08 Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3908	C								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110		0.00							
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg TRIM RIVETS 1.185" LONG								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

EP 11/02/08 (Signature)EP 11/02/08 (Signature)(Signature)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66027**

Wednesday, February 02, 2011 9:11:44 AM

Page 2

Item ID: D3908-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Lug Assembly, Aft

Start Date: 2/3/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 2/16/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: S/O

0.00



Packaging

Memo

0.00

Packaging

11/2/9 sf 40

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/10 dfMF  
11-02-09

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, February 02, 2011 9:11:40 AM

Page 1

Work Order ID: 66027

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft



Start Date: 2/3/2011

Required Date: 2/16/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC  
As per Rev B 10-04-06 VERIFIED BY:DD  
10.05.27 DD verf:EC  
10.05.28 DD verf:EC  
IPP REVB:  
IPP Rev:C as per PC1  
IPP Rev:D per ECN10-581

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6  Lanyard Assembly		Manufactured	No			100	Each	5.0000	1	6			
<div> <div> <u>Location</u> ST020 65617 </div> <div> <u>Loc Qty</u> 5 5 </div> <div> <u>Loc Code</u>  </div> </div>													
D3908-1  Lug Plate, Aft Crosstube		Manufactured	No			100	Each	20.0000	2	12			
<div> <div> <u>Location</u> ST093 65624 ST094 60035 ST095 58344 </div> <div> <u>Loc Qty</u> 9 9 6 6 5 5 </div> <div> <u>Loc Code</u>  </div> </div>													
D3908-3  Stud Receiver, Lower		Manufactured	No			100	Each	8.0000	1	6			
<div> <div> <u>Location</u> ST095 57816 58849 60228 </div> <div> <u>Loc Qty</u> 8 2 1 5 </div> <div> <u>Loc Code</u>  </div> </div>													

EPB 11/02/08  
B59960 (40)

EPB 11/02/08

EPB 11/02/08

u

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 66027

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 2/3/2011

Required Date: 2/16/2011

Start Qty: 6.00

Required Qty: 6.00

D3908-5  
  
 Eyebolt Stud

Manufactured No

100 Each

15.0000

1

6



*EP 11/02/08*

Location

Loc Qty

Loc Code

GA

1

57428

1

ST090

12

65625

12

ST095

2

59670

2

4

D3910-1  
  
 Crosstube Lug

Manufactured No

100 Each

1.0000

1

6



*EP 11/02/08*

Location

Loc Qty

Loc Code

st507

1

59708

1

65631 (1X)

B59349 (3X)

D4091-1  
  
 Mounting Lug

Manufactured No

100 Each

2.0000

1

6



*EP 11/02/08*

Location

Loc Qty

Loc Code

ST460

2

62392

2

360874 (CK)

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, February 02, 2011 9:11:41 AM

Page 3

Work Order ID: 66027

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 2/3/2011

Required Date: 2/16/2011

Start Qty: 6.00

Required Qty: 6.00

AN3C12A Purchased No 100 Each 56.0000 2 12  
Bolts

Location	Loc Qty	Loc Code
ST351	56	
112314	8	
114761	11	
116022	2	
116289	17	
116428	18	

AN4C13A Purchased No 100 Each 36.0000 1 6  
BOLT

Location	Loc Qty	Loc Code
ST357	36	
113359	3	
114442	5	
114615	2	
116191	26	

MS17984-C413 Purchased No 100 Each 12.0000 1 6  
PIN, QUICK RELEASE

Location	Loc Qty	Loc Code
ST315	12	
116706	12	

MS20615-41120 Purchased No 100 Each 126.0000 6 36  
RIVET

Location	Loc Qty	Loc Code
ST323	126	
114808	26	
115054	100	

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, February 02, 2011 9:11:41 AM

Page 4

Work Order ID: 66027

Parent Item: D3908-041


Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 2/3/2011

Required Date: 2/16/2011


Start Qty: 6.00

Required Qty: 6.00

MS21043-3 Purchased No 100 Each 1,570.000 2 12  
  
Nut


Location Loc Qty Loc Code

FG 76  
103691 76  
ST301 1494  
112314 1494

MS21043-4 Purchased No 100 Each 1,163.000 1 6  
  
Nut

Location Loc Qty Loc Code

ST301 1163  
114523 5  
114784 2  
115936 260  
116188 596  
116549 300

NAS1149C0332R Purchased No 100 Each 4,296.000 4 24  
  
Washer

Location Loc Qty Loc Code

ST297 4296  
115000 125  
115698 35  
116025 1136  
116304 3000

Wednesday, February 02, 2011 9:11:41 AM

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 5

Wednesday, February 02, 2011 9:11:41 AM

Work Order ID: 66027

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 2/3/2011

Required Date: 2/16/2011

Start Qty: 6.00

Required Qty: 6.00

NAS1149C0432R

Purchased

No

100

Each

148.0000

2

12



*EP 11/12/08*

Washer

Location

Loc Qty

Loc Code

ST297

148

114292

36

114742

21

116304

91

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

*M116805 (8x)*

Wednesday, February 02, 2011 9:11:41 AM

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

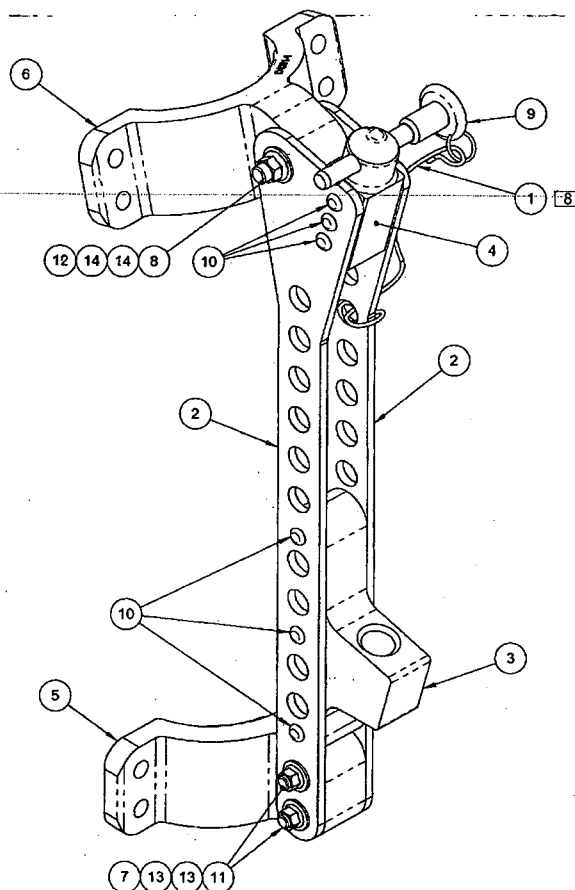
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	1	D3910-1	X-TUBE LUG
6	1	D4091-1	MOUNTING LUG
7	2	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	6	MS20615-4M20	RIVET
11	2	MS21043-3	NUT
12	1	MS21043-4	NUT
13	4	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER



**D3908-041 X-TUBE LUG ASSY (AFT)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.34 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

**RELEASED**  
2010-05-28  
W

C	REDESIGNED ITEM #2: ITEM#6 REPLACES QTY 1 ITEM#5; QTY 2 FOR ITEMS #7 & 11 WAS QTY 4, QTY 8 FOR ITEM #13 WAS 4, ADDED ITEMS #8, 12 & 14	MB	10.05.27
B	BOM: D3908-5 REPLACED WITH D3908-5, QTY 1 ADDED: D2690-6 & MS17984-C413, SHEET 5: ADDED D3908-5	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.05.27		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3908</b> TITLE <b>X-TUBE LUG ASSY (AFT)</b> REV. C SHEET 1 OF 5 SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

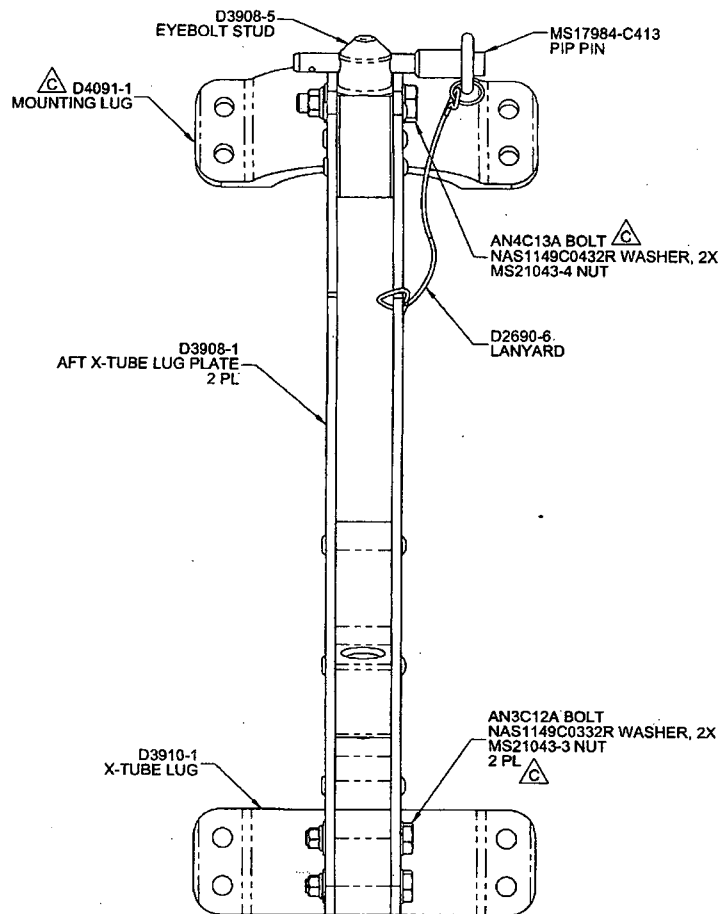
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**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1



#66027

**RELEASED**  
2010-05-28  
MP

**D3908-041 X-TUBE LUG ASSY (AFT)**

DESIGN	JFH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3908	SHEET 2 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		X-TUBE LUG ASSY (AFT)	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.05.27		

8 7 6 5 4 3 2 1

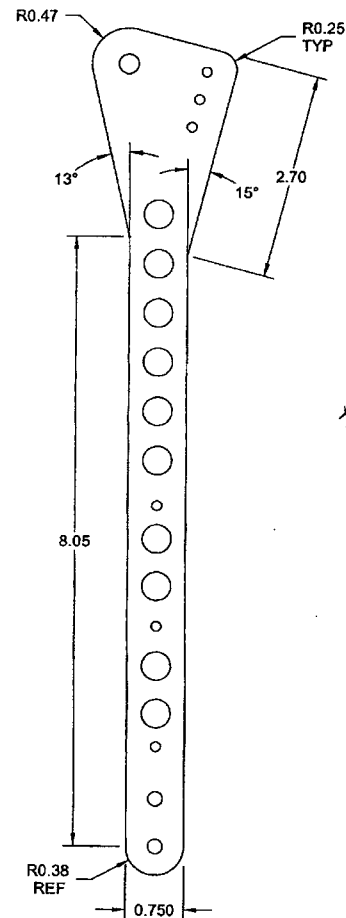
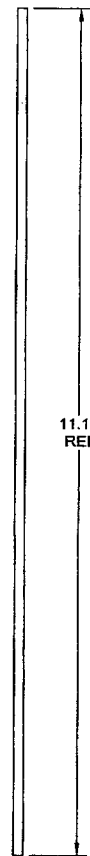
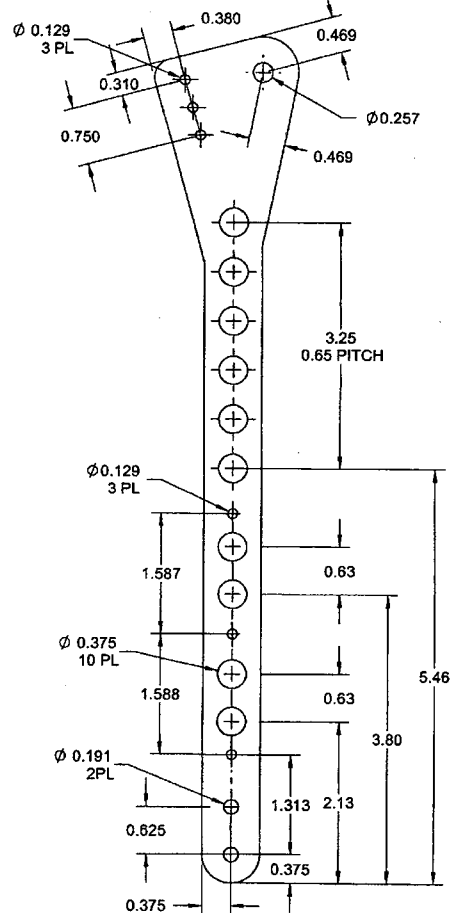
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**NOTE:** Date & initial all entries



#66027

RELEASED  
2010-05-28

# NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.31 lbs

## D3908-1 AFT X-TUBE LUG PLATE

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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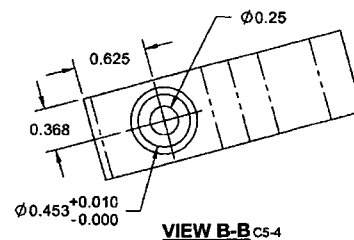
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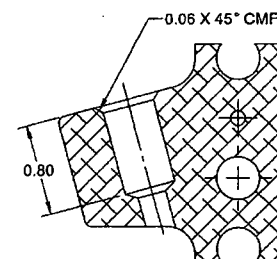
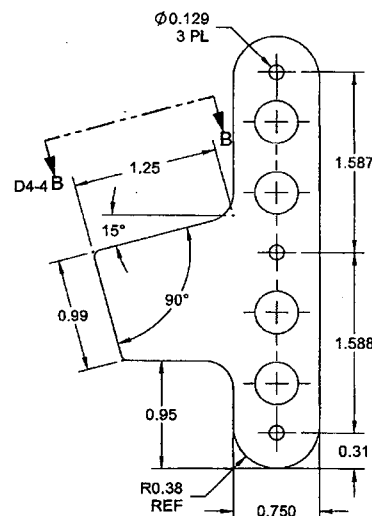
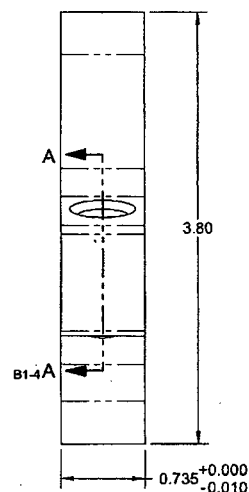
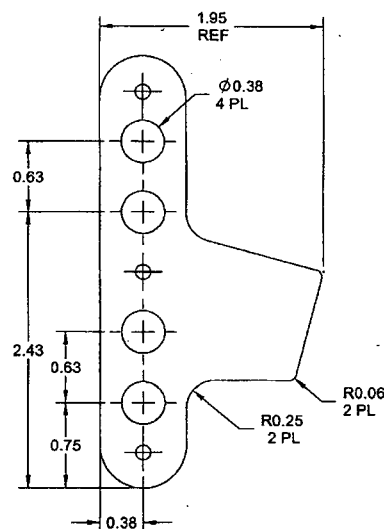
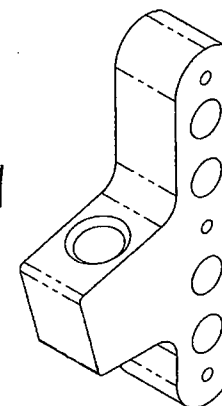
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




# **D3908-3 STUD RECEIVER LOWER**

## **NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276  
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.69 lbs

**RELEASED**  
2010-05-28

DESIGN	JFH	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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# Dart Aerospace Ltd

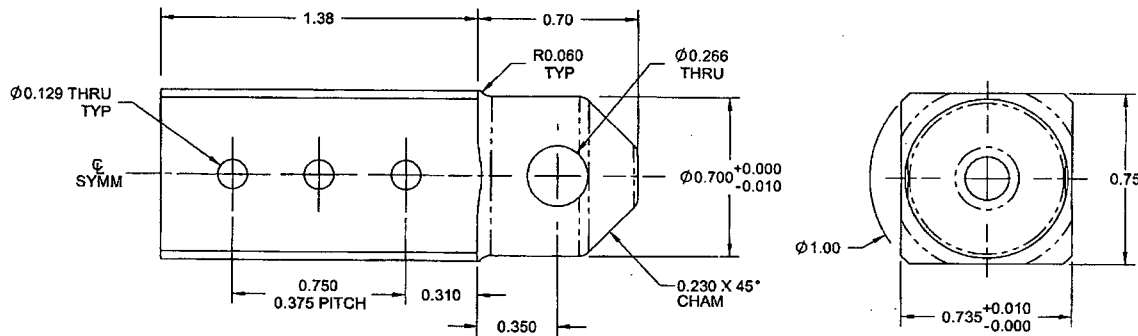
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3908-5 EYEBOLT STUD**

**RELEASED**  
2010-05-28  
MD

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	JFH	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries